

# Work Order ID 51523

August 25, 2009 1:35:05 PM

Page 1

Item ID: D2574

Accept

Revision ID: E

Item Name: Saddle, Aft In 205

Start Date: 8/28/09

Start Qty: 24.00

Required Date: 9/18/09

Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-25 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 51523 Double check by: mf 11-Machine Step  
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine  
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-  
Machine Step No 3 per Folio FA051 and insp

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51523

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Page 2

Item ID: D2574

Accept

Revision ID: E

Item Name: Saddle, Aft In 205

Setup Start

Stop

Start Date: 8/28/09 Start Qty: 24.00

Required Date: 9/18/09 Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 09/09/18

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MO 09/09/21

(XB)

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

12:20

11:50

320°F

M112260

M-L 09/09/21

(6X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51523

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Page 3

Item ID: D2574

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft In 205

Start Date: 8/28/09 Start Qty: 24.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PC 9/9/21 (6)

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Memo

0.00

Packaging

PC 9/9/21 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/22 HJ  
MF 09-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 25, 2009 1:35:05 PM

Page 1

Work Order ID: 51523

Parent Item: D2574RevE

Parent Item Name: Saddle, Aft In 205


Comments:

Start Date: 8/28/09

Required Date: 9/18/09

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005RevB		Manufactured	No			110	Each	0.0000	24.0000			
												
Saddle Billet												

Batch # B46411

09/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51523</b>
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	<b>D2574</b>
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.503		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.502	.502	.502	.504		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.572	.572	.571	.573		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.370	1.370	1.368		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	4.119	4.129		4.124	4.122	4.123	4.122		
P	0.115	0.135		.126	.124	.123	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.248	.248	.249		
S	0.115	0.135		.130	.129	.128	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.229	3.230	3.230		
V	0.230	0.250		.239	.237	.238	.238		
W	0.115	0.135		.119	.122	.120	.120		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.626	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.247	.247	.247		
AE	1.500	1.520		1.509	1.509	1.509	1.509		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.280	.270	.270	.270		
AH	0.240	0.260		.251	.247	.249	.249		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>ML</i>
Date:	09/09/18

Audited by:	<i>K.A</i>
Date:	09/09/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>ML</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>51523</b>
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	<b>D2574</b>
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	51	61	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.502	.501				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.503	.501				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.573	.571				
L	1.174	1.184		1.178	1.178				
M	1.365	1.375		1.369	1.369				
N	2.495	2.505		2.499	2.499				
O	4.119	4.129		4.123	4.123				
P	0.115	0.135		.123	.123				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.249	.247				
S	0.115	0.135		.131	.129				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.237	.237				
W	0.115	0.135		.120	.125				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.368				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.246	.247				
AE	1.500	1.520		1.509	1.508				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.270	.275				
AH	0.240	0.260		.247	.247				
AI	2.000	2.020		2.001	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

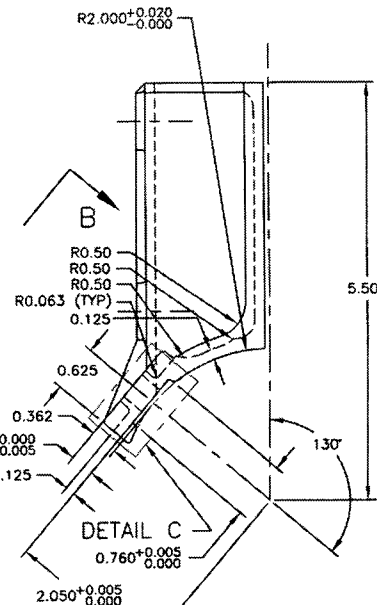
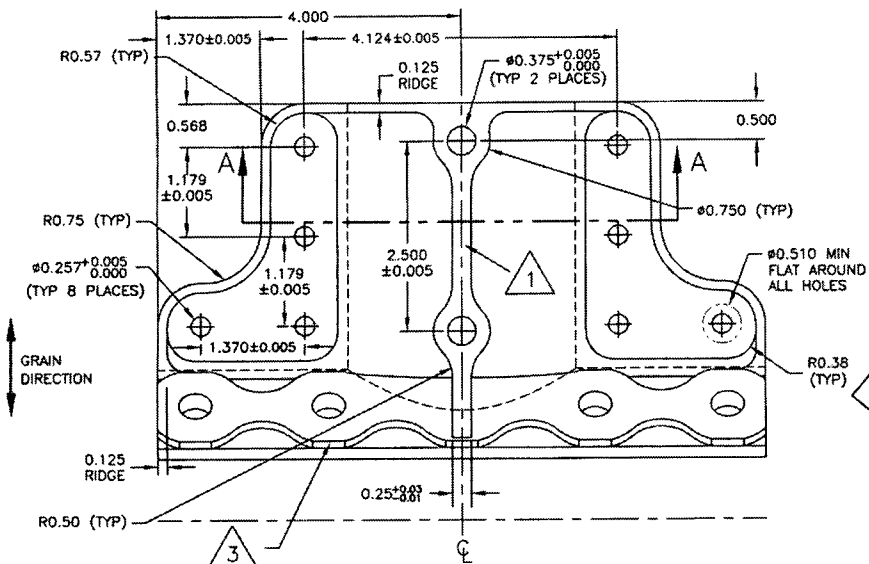
Measured by:	<i>SM</i>
Date:	09/09/18

Audited by:	<i>H.A</i>
Date:	09/09/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

RELEASED

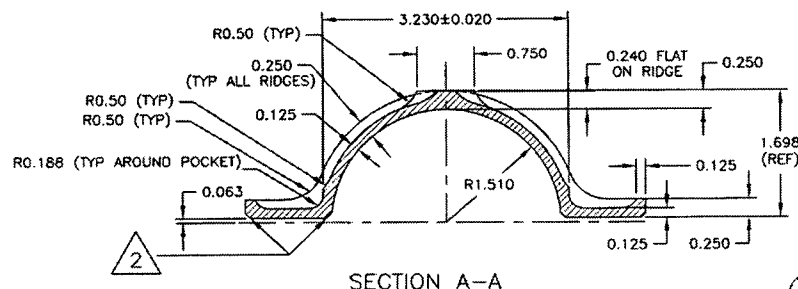
05.12.06



# NOTES

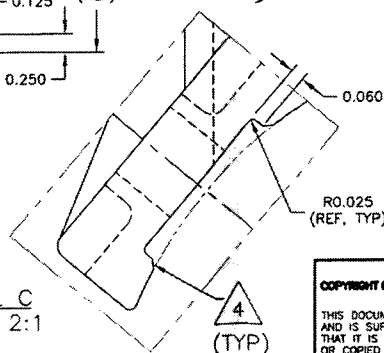
MATERIAL: 7075-T7351 (Q0-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

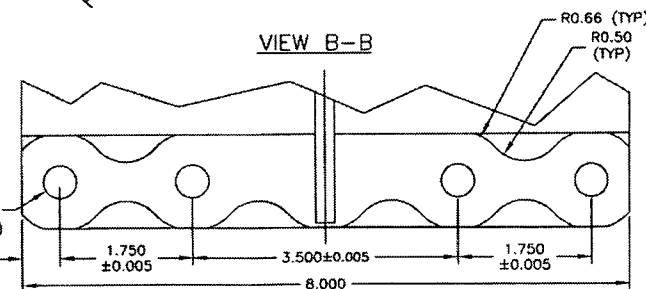


SECTION A-A

51523



DETAIL C  
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	TITLE INNER AFT SADDLE
DART AEROSPACE LTD.	DART AEROSPACE LTD.	WORKSHEAT, ONTARIO, CANADA
DRAWING NO. D2574	REV. E	SHEET 1 OF 1
SCALE	2:3	

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